

Adelphi HTA306-1

High Temperature Ceramic and Graphite Adhesives

Adelphi HTA306-1 is a single component high temperature ceramic and graphite adhesive, it has a wide application in bonding, potting and sealing of following:

- Ceramics
- Composites
- Graphite
- Metals
- Quartz
- Semiconductors

The applications are for temperatures up to 3200 °F (1760°C). HTA306-1 is recommended in all type of mechanical, electrical, instruments and sensor applications.

Temperature Limit, °F (°C)	Components	Ratio	Viscosity, cP	CTE, in/in/°F x 10-6 (°C)	Application Temperature, °F(°C)	Air Set, Hours	Heat Cure, °F, Hrs	Shelf Life, Months
3200 (1760)	2	1:1 1.5:1	20000-90000	7.0(12.6)	50-90 (10-32)	1-4	200, 2	6

Dielectric Strength, volts/mil @ RT	Torque Strength, ft-lbs	After curing at 700 °F for 2 hours.		
		Moisture resistance	Alkali Resistance	Acid Resistance
91	22	Excellent	Good	Fair

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Surface Preparation

For smooth surfaces etching, abrasive blasting or oxidization is required, followed by thorough cleaning prior to application.

Porous substrates should be pre-coated with a binder to prevent separation and absorption of the adhesive binder.

Preparation of Adhesive

Always stir each part thoroughly first. Proportion accurately and mix slowly to avoid entrapping air.

Application

Apply a thin coat of adhesive to each surface using a brush, spatula or dispenser.

Using a clamp or similar tool, maintain a uniform glue line of 2-8mils (200-500 microns) by applying even pressure across the assembly.

Wipe away excess material prior to drying.

Curing

HTA306-1 requires an air set time of 1-4 hours followed by 2 hours @ 200F.

Technical Questions? Call us. We are happy to help! +631-537-8390

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